

Date: Friday, 9/15/2006 11:59:21 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SLIDING PLATE
<b>Job Number</b> : 28616	
<b>Estimate Number</b> : 11215	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D33333
<b>This Issue</b> : 9/15/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3333 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 25684	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 10/5/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>06 09 15</u>	
<b>Comment</b> : Est. A05.01.13 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010B4000X00500	AISI 1010-1025 Steel Bar
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**Comment:** Qty.: 0.7984 f(s)/Unit Total: 7.9842 f(s)

AISI 1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel

(M1010-B4.000x00.500)

Identify for D3333-3

Batch: M102210

06/10/03

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 4.000" x 0.500" thick x 9.620" long

06/10/03

10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA483 and Dwg D3333

Identify as D3333-3

06/10/11

10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

06/10/11

10

5.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

06/10/12

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/11/09

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:59:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING PLATE

Job Number: 28616

Part Number: D33333

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333

J.F. 06/11/07 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/11/07 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes and sides

FC 06 11 07 (10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M. 06/11/07 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STO1

Plc 06.11.08 (2) B 06/11/08 (8)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

S 06/11/07

Job Completion



W 06/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28616
<b>Description:</b> Sliding Plate		<b>Part Number:</b> D3333-3
<b>Inspection Dwg:</b> D3333	<b>Rev:</b> B	<b>Page</b> 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+/-0.010	3.899	✓			
9.50	+/-0.030	9.501	✓			
0.650	+/-0.010	0.651	✓			
2.310	+/-0.010	2.309	✓			
1.125	+/-0.010	1.122	✓			
1.950	+/-0.010	1.947	✓			
1.200	+/-0.010	1.195	✓			
1.300	+/-0.005	1.300	✓			
R0.125	+/-0.010	0.125	✓			
0.500	+/-0.010	0.495	✓			
0.440	+/-0.010	0.439	✓			
1.675	+/-0.010	1.674	✓			
0.035 x 45°	+/-0.010	0.035 x 45°	✓			
0.485	+0.000 -0.010	0.485/0.478	✓			

<b>Measured by:</b> <i>ES</i>	<b>Audited by:</b> <i>nm</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 06/10/11	<b>Date:</b> 06/10/11	<b>Date:</b> N/A

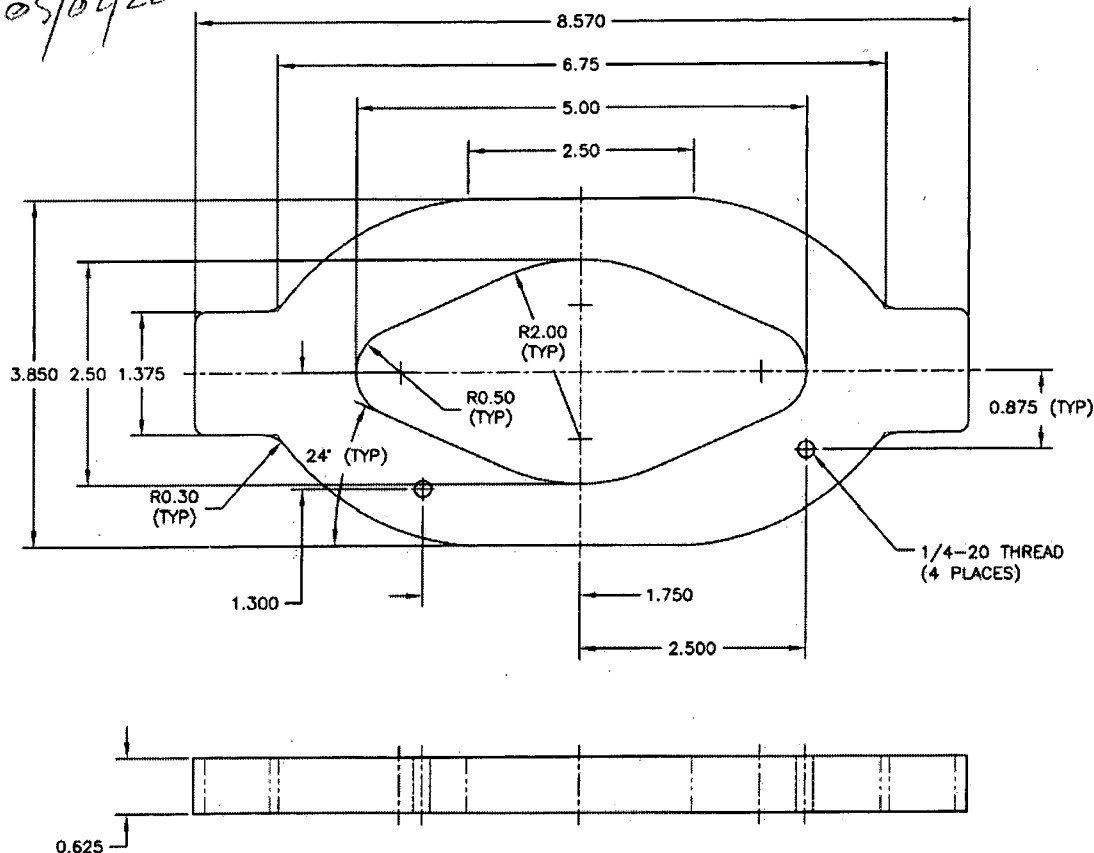
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

**RELEASED**

05/02/22

**D3333-1 BASE PLATE PANEL****NOTES:**

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)  
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

NO. 28616

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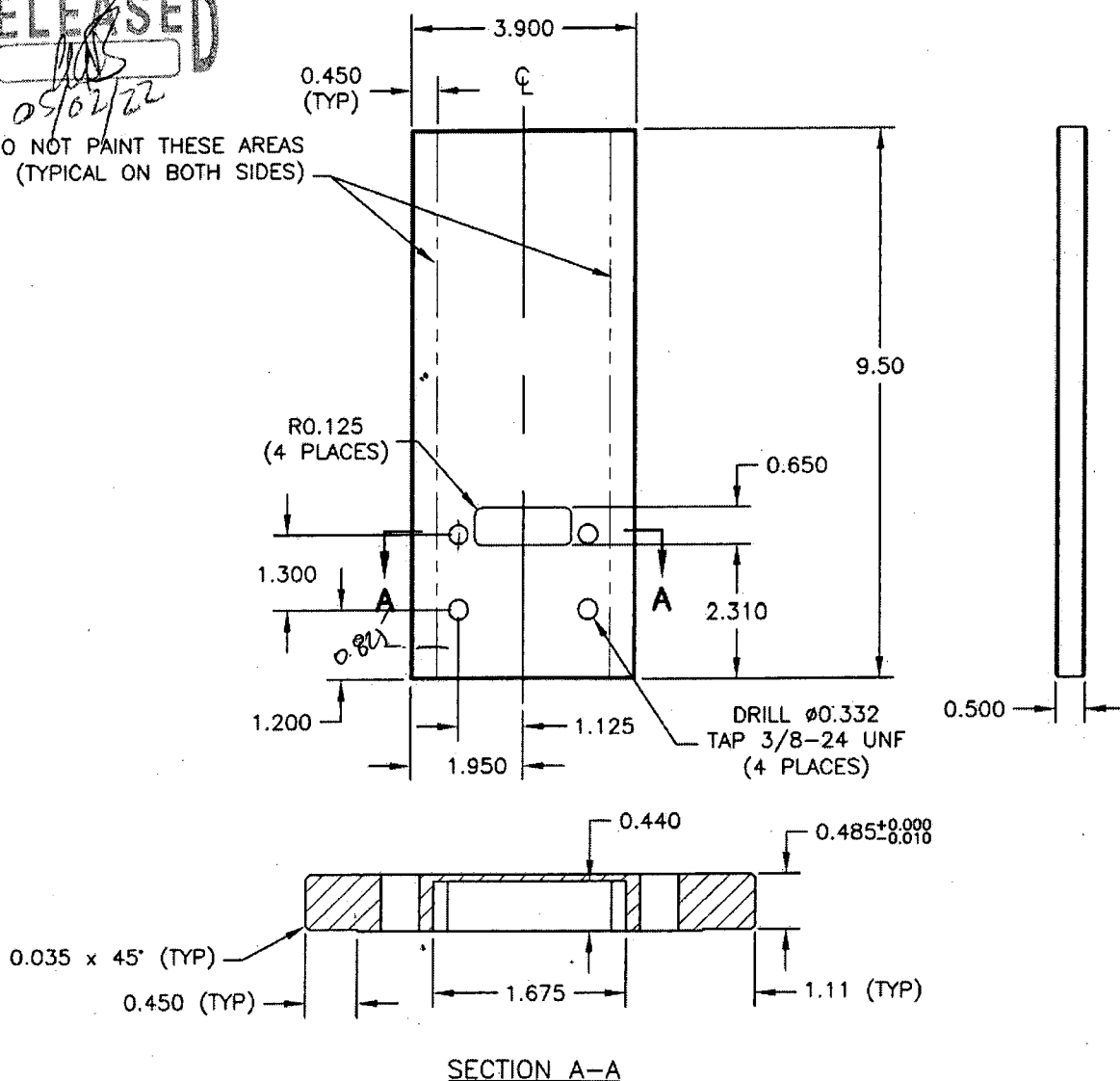
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CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18	TITLE PLATE		SCALE 1:4

RELEASED  
05/02/22

DO NOT PAINT THESE AREAS  
(TYPICAL ON BOTH SIDES)



### D3333-3 SLIDING PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

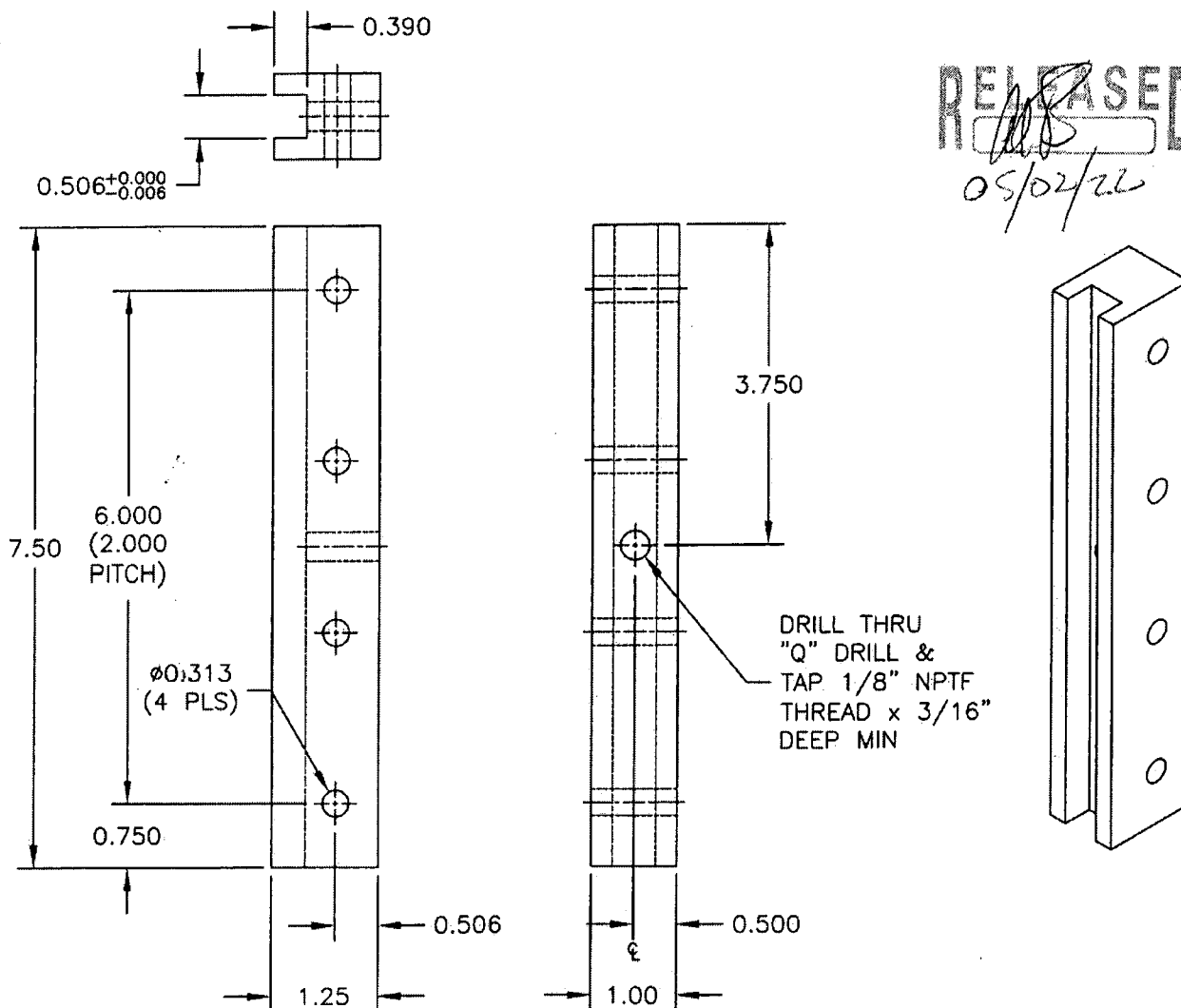
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18	TITLE PLATE		SCALE 1:2



### D3333-5 RAIL

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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